

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023702**Date Inspected:** 12-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** N / A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP. The QAI noted that the contractor is currently addressing the TL-20 comments and reports that have been identified through the field splice tracking log. The QAI noted that formal reports have not been submitted at this time.

The QAI met with the QAI Robert Mertz and continued to conduct Ultrasonic Testing (UT) verification of the full height ElectroSlag Welding (ESW) weld trial (mock up). The QAIs noted that there are very minor indications that can be observed during the UT examination. The QAI noted that no rejectable indications were observed during the verification testing of the mock up. The QAIs marked out 6 locations where the contractor will cut coupons from the mock up in order to provide macro-etched specimens for examination. As the QAI completed the UT verification, the contractor's personnel began cutting the 150mm x 75mm sections from the mock up. See the attached photos.

The QAI was requested to sample fastener assemblies that have been delivered to the contractor's job site storage area. The QAI met with Caltrans Transportation Engineer Bob Brignano and was provided with the fastener assemblies and the rocap documents. The QAI pulled random samples to satisfy the contract requirements for verification samples. The QAI assigned lot number B212-014-11 and generated a TL-102 form with the pertinent information.

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Summary of Conversations:

The QAI relayed the status of document reviews and the ESW mock up testing to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer